

Work Order ID 153888

Monday, November 28, 2016 10:33:33 AM

153888

Page 1

Item ID: **D3166-3** Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Hoop
 Start Date: 11/28/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/2/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **NOV 28 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3166	Rev A1								
100		0.00							
100									
Large Fab	Memo	0.03							
Large Fab	Cut 3/4" x 3/4" square tubing 120.00" long.								
110		0.20							
110									
CNC Bend 1	Memo	0.04							
CNC Delta 100 Bender	Form D3166-3 Basket Hoop as per Dwg D3166 using Bending program 350 BASL, and Folio FT005								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS 24 9-89

DEC 06 2016

DP 16-12-12

DAS 43 9-89

DEC 13 2016

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐		
NCR No. _____		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☒		
		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐		
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐		
Date :	Step #:	QTY Effective :							MRB (QS1042) Approval				
Description Work Order Deviation				Disposition									
DESCRIPTION OF THE DEFECT OR NON-CONFORMANCE DATE OF OCCURRENCE QUANTITY AFFECTED				REASON FOR DEFECT ACTION TAKEN TO CORRECT THE DEFECT APPROVALS									
												Completed By	
												Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval									
Root Cause				FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐		
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐		
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐		
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐		
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐		
Past Expiry Date	☐	Manufacturing Process	☐										
Misidentified	☐	Past Due	☐	OTHER :									

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>WVA 04</i>	0.00							
130									
Packaging	Memo	0.01					<i>8x</i>	DAS 43	DEC 13 2016
Packaging	LOCATION : WA004							9-89	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.13					DAS 21		DEC 14 2016
Quality Control							9-89		
								DAS 21	DEC 13 2016
								9-89	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Monday, November 28, 2016 10:33:35 AM

Page 1

Work Order ID: 153888

153888

Parent Item: D3166-3

D3166-3

Parent Item Name: Basket Hoop

Start Date: 11/28/2016

Required Date: 12/2/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A02.08.23New issueKJ
IPP Rev:B 09-01-23 as per DEO D3166-A2 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	672.0000	10	84.21053			DAS 24 9-89
M304TS0 750W 065										**		DEC 06 2016	

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA004

672

m133412

272

m135655

400

84.21053

DG

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

RELEASED
02.08.06

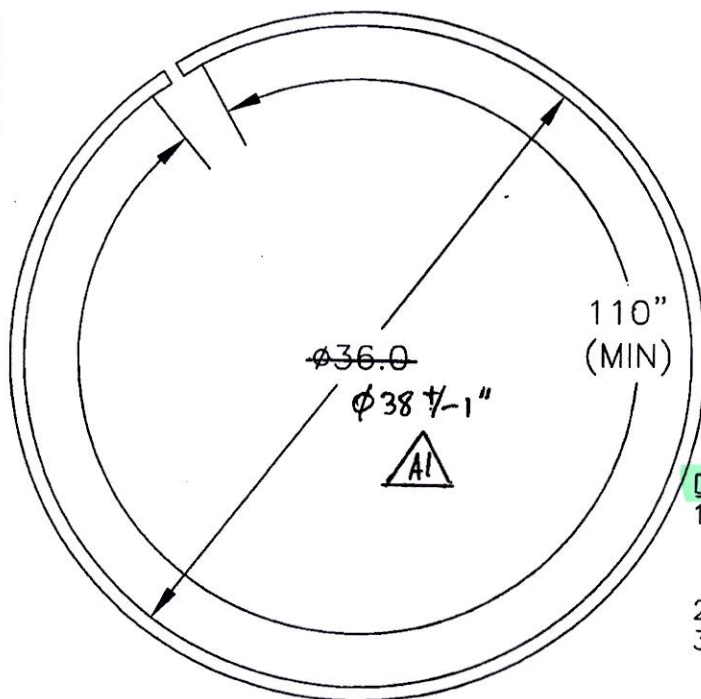
DEO ATTACHED

R12.0

10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153888 M-5
10-11-08

D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Date ☐	Equip/Tooling ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Outside Dimensions ☐
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				Marks/Chatter ☐	Misaligned/off center ☐		
				OTHER : _____			

DRAWING NO. D3166	TITLE BASKET HOOP	REV A1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08.12.16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, **3/4 X 3/4 X 0.065** WALL SQUARE TUBING,
60.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 60.00" LONG
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR **D3166-3** AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, **3/4 X 3/4 X 0.065** WALL SQUARE TUBING,
120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING,
0.75" x 0.75" x 0.063 WALL, 120.00" LONG
(REF DART SPEC. M304TS0.750W.063)

RELEASED
08/12/16 *[Signature]*

REASON: SEE PAR 08-005

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